

Work Order ID 96917-2

Tuesday, February 12, 2013 9:24:12 AM

96917

Page 1

Item ID: D2807-041

Revision ID:

Item Name: Door prop

Start Date: 2/12/2013

Required Date: 2/28/2013

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: 13-2-12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2807

Rev E

100

100

Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 19080 Order as per Dwg D2807Possible
supplier: Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N

Material release note is required

CL 13/02/12 (20)

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure Material Release Note is attached

143/2/10 (6)

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

*DAS
15
2-12*

15.2 19

6



Work Order ID 96917

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Page 2

Item ID: D2807-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door prop

Start Date: 2/12/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/28/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-install D3671-1 as per dwg D2807

6x

13/02/19

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

SMD
132-19

6

150

150

Packaging

Identify as per dwg & Stock Location: SE18

0.00

Memo

0.00

Packaging

6x

13-2-19



Work Order ID 96917

Tuesday, February 12, 2013 9:24:12 AM

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Page 3

Item ID: D2807-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door prop

Start Date: 2/12/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/28/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

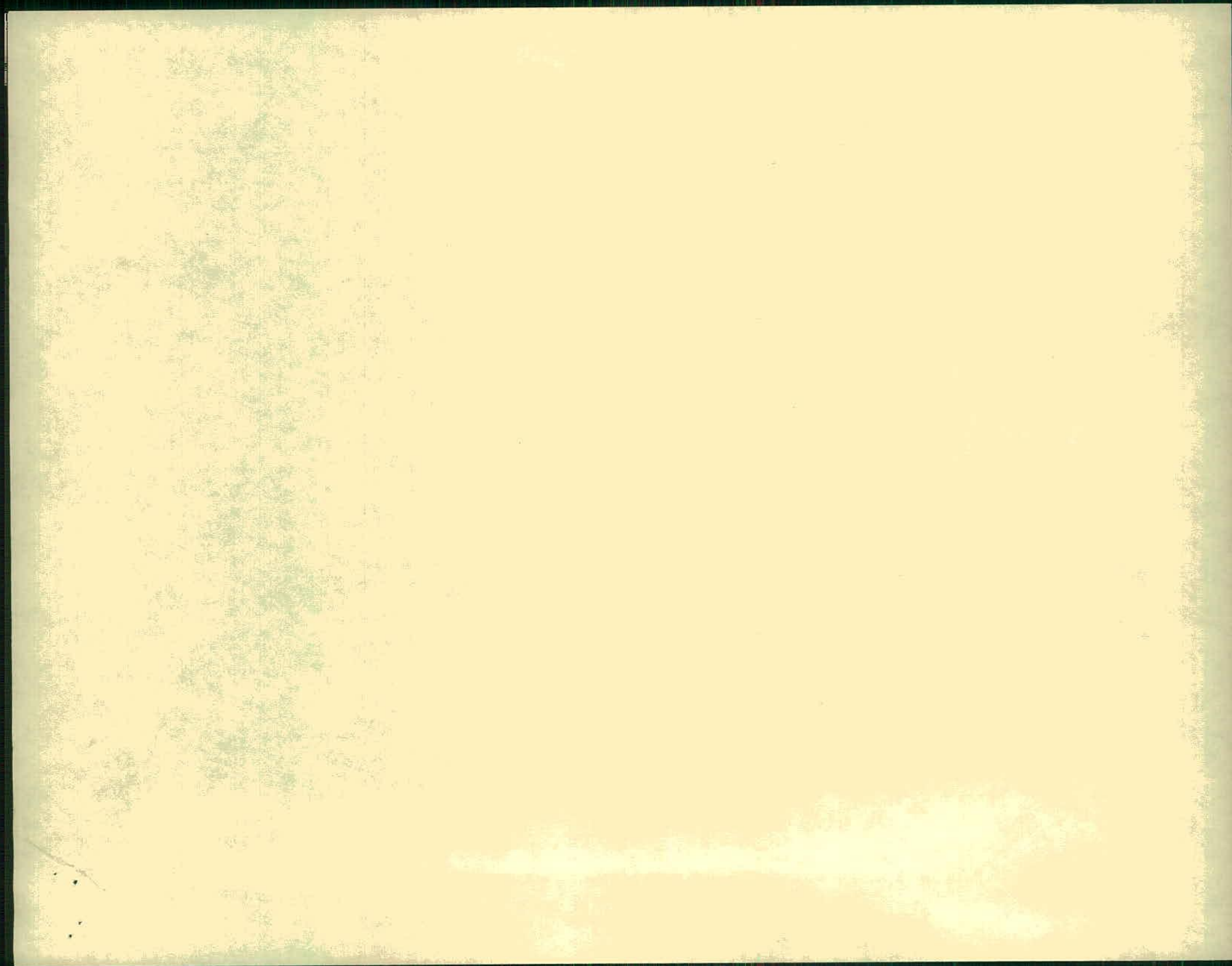
Memo

0.00

Quality Control

13/2/21 *[Signature]*

113-02-20



Picklist Print

Tuesday, February 12, 2013 9:24:12 AM

Page 1

Work Order ID: 96917

Parent Item: D2807-041

Parent Item Name: Door prop

Start Date: 2/12/2013

Required Date: 2/28/2013

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
* D3671-1 Placard		Manufactured	No			110	Each	20.0000	1	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		20							
				89660		8				3			
				95783		12							
6/15-164/50-115N		Purchased	No			130	Each	0.0000	1	12			
Gas Spring													

13/02/19
383607 (30)

14/13/2/15
(6)



SPECIFICATION CONTROL DRAWING

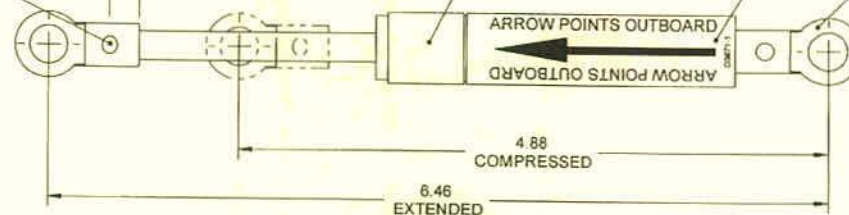
(8)
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\phi 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

(8)
0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(8)
(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

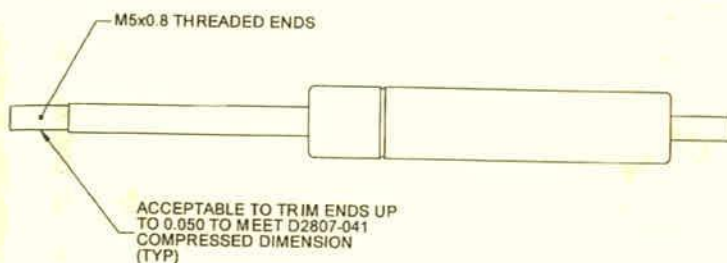
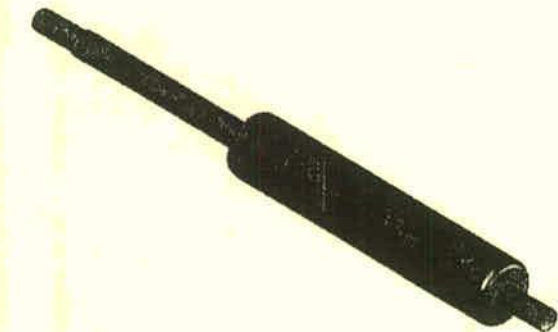
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING: D2807-1/3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE

DESIGN	#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	#		
CHECKED	#	DRAWING NO.	REV. E
MFG APPR	#	D2807	SHEET 1 OF 3
APPROVED	#	TITLE	SCALE
DE APPR	#	GAS SPRING	NTS
DATE	07.12.28	COPY RIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

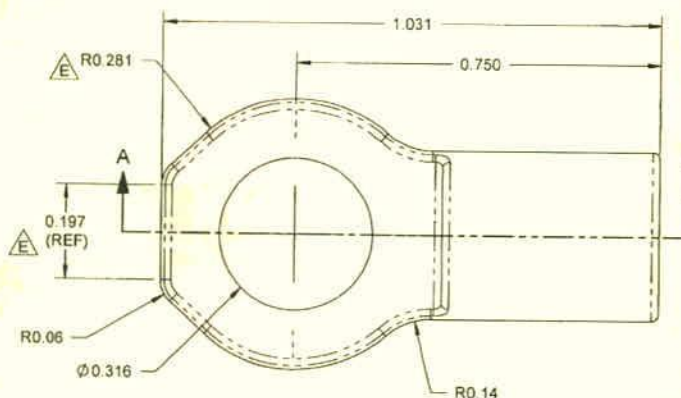
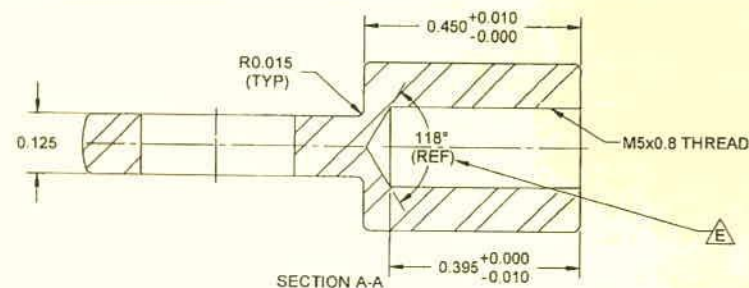




D2807-1 GAS SPRING
SCALE 1:1

D2807-1 GAS SPRING NOTES:

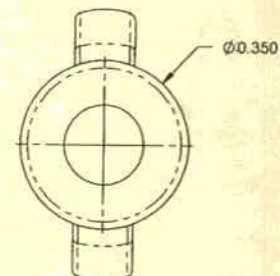
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS



D2807-3 LUG

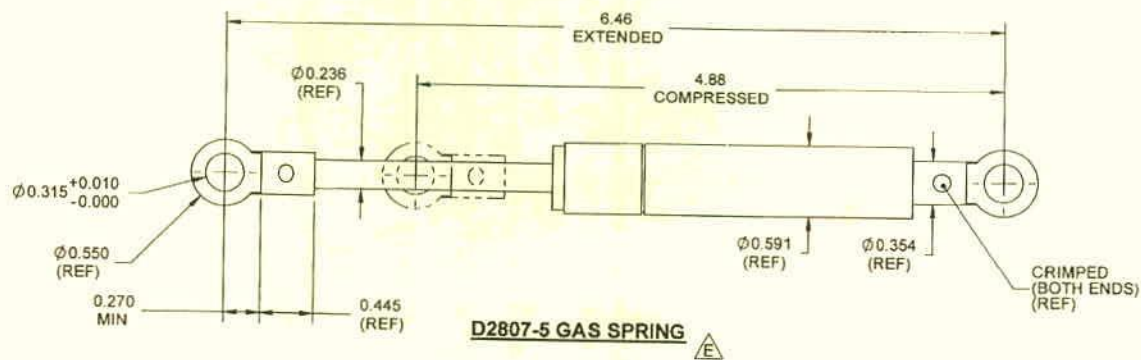
D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LF	DRAWING NO.	REV. E
MFG. APPR.	LF	D2807	SHEET 2 OF 3
APPROVED	LF	TITLE	SCALE
DE APPR.	LF	GAS SPRING	4:1
DATE	07 12 28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS.
ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO. D2807	REV. E
MFG. APPR.	KE	TITLE GAS SPRING	SHEET 3 OF 3
APPROVED	PH	SCALE 4:1	
DE APPR.	PH	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19080

Purchase Order Date 2/12/13

PO Print Date 2/12/13

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

306 683 5000

306 683 6403

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FXED
2/13/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	2/15/13 Yes	20.00 Each	FedEx PI collect	\$63.9000	\$1,278.00

Special Inst: AS PER DWG D2807 REV. E
B96917

PO Total:

\$1,278.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr:

1

Change Date: 2/12/13

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required - YES NO



314 Jessop Ave
Saskatoon, SK S7N 1Y6

Packing Slip

P.O. No.	Date	Invoice #
19080	2/13/2013	9523

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
2/13/2013		

Qty	Description
6	D2807-041 Stainless Gas Spring (6/15-164/50-115N) D2807-041 B96917 Shipping Via FED EX Tracking # 794746469512





LS Technologies Inc

314 Jessop Ave

Saskatoon, SK, S7N 1Y6

Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Feb 13, 2013

This is to certify that the parts listed below meets specifications as required by your order.

6 Units: D2807-041 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada

Date of Manufacture : Oct 2012

This product is ROHS compliant.

Purchase Order # 19080

Inv# 9523

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President

